

Date: Thursday, 9/20/2007 3:26:43 PM  
User: Kim Johnston

## Process Sheet

|                       |  |                  |                |
|-----------------------|--|------------------|----------------|
| Customer              | : CU-DAR001 Dart Helicopters Services              | Drawing Name     | : DOOR         |
| Job Number            | : 34738  |                  |                |
| Estimate Number       | : 12954  |                  |                |
| P.O. Number           | : N/A  | Part Number      | : D32597       |
| This Issue            | : 9/20/2007 S.O. No. : N/A                         | Drawing Number   | : D3259 REV A1 |
| Prsht Rev.            | : NC   | Project Number   | : N/A          |
| First Issue           | : N/A Type : SMALL /MED FAB                        | Drawing Revision | : A1           |
| Previous Run          | : 34254  | Material         | : N/A          |
| Written By            | :  | Due Date         | : 10/10/2007   |
| Checked & Approved By | : <u>07-08-20</u>                                  | Qty:             | 10             |
| Comment               | : Est Rev A New Issue 07-07-19 JLM Verified By: EC | Um:              | Each           |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s)

2024-T3 .063sheet

Batch: M16052 1B 07-09-28

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3259

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary 1B 07-09-28

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

|     |                 |                            |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



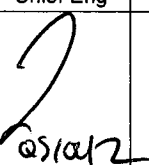


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-09-01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3259-7 PAR #: N/A Fault Category: Prod / Fab. Ass. <sup>MED & Small</sup> NCR: (Yes) No DQA: 12 Date: 07/10/05  
 QA: N/C Closed: 12 Date: 07.10.05

| NCR: 34738 |         | WORK ORDER NON-CONFORMANCE (NCR)   |   |                                    |   |                           |   |                          |
|------------|---------|--|---|------------------------------------|---|---------------------------|---|--------------------------|
| DATE       | STEP    | Description of NC<br>Section A   | Corrective Action Section B   |                                    |   | Verification<br>Section C | Approval<br>Chief Eng   | Approval<br>QC Inspector |
|            |         |  | Initial<br>Chief Eng  | Action Description<br>Chief Eng    | Sign &<br>Date  |                           |   |                          |
| 07/04/28   | #<br>20 | two parts scrap.<br>wrong mat. used.<br>(M16052)<br>R.C. wrong mat. used | <br>05/10/2 | scrap the two parts<br>and replace | <br>07-09-28 | En<br>07/04/28            | <br>05/10/2 | En<br>07/09/28           |
|            |         |  |   |                                    |   |                           |   |                          |
|            |         |  |   |                                    |   |                           |   |                          |

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:26:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 34738

Part Number: D32597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PO 7/10/02 (12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57176

PO 7/10/02 (12)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)  
D 8/10/05

Job Completion



u 87-0003

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                              |                |                             |
|------------------------------|----------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |                | <b>Work Order:</b> 34738    |
| <b>Description:</b> Door     |                | <b>Part Number:</b> D3259-7 |
| <b>Inspection Dwg:</b> D3259 | <b>Rev:</b> A1 | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 10.008            | +/-0.010      | 10.008           | X      |        |                      |          |
| 9.000             | +/-0.005      | 9.000            | X      |        |                      |          |
| 1.000             | +/-0.005      | 1.000            | X      |        |                      |          |
| 0.260             | +/-0.010      | .260             | X      |        |                      |          |
| R0.130            | +/-0.010      | .130             | X      |        |                      |          |
| 5.960             | +/-0.010      | 5.960            | X      |        |                      |          |
| 0.548             | +/-0.010      | .548             | X      |        |                      |          |
| 0.626             | +/-0.010      | .626             | X      |        |                      |          |
| 11.250            | +/-0.005      | 11.250           | X      |        |                      |          |
| Ø0.313            | +0.005/-0.000 | .313             | X      |        |                      |          |
| Ø0.098            | +0.005/-0.000 | .100             | X      |        |                      |          |
| 3.308             | +/-0.010      | 3.308            | X      |        |                      |          |
| R0.46             | +/-0.030      | .46              | X      |        |                      |          |
| 0.063 thick       | +/-0.010      | .062             | X      |        |                      |          |
| 0.059             | +/-0.010      | .059             | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

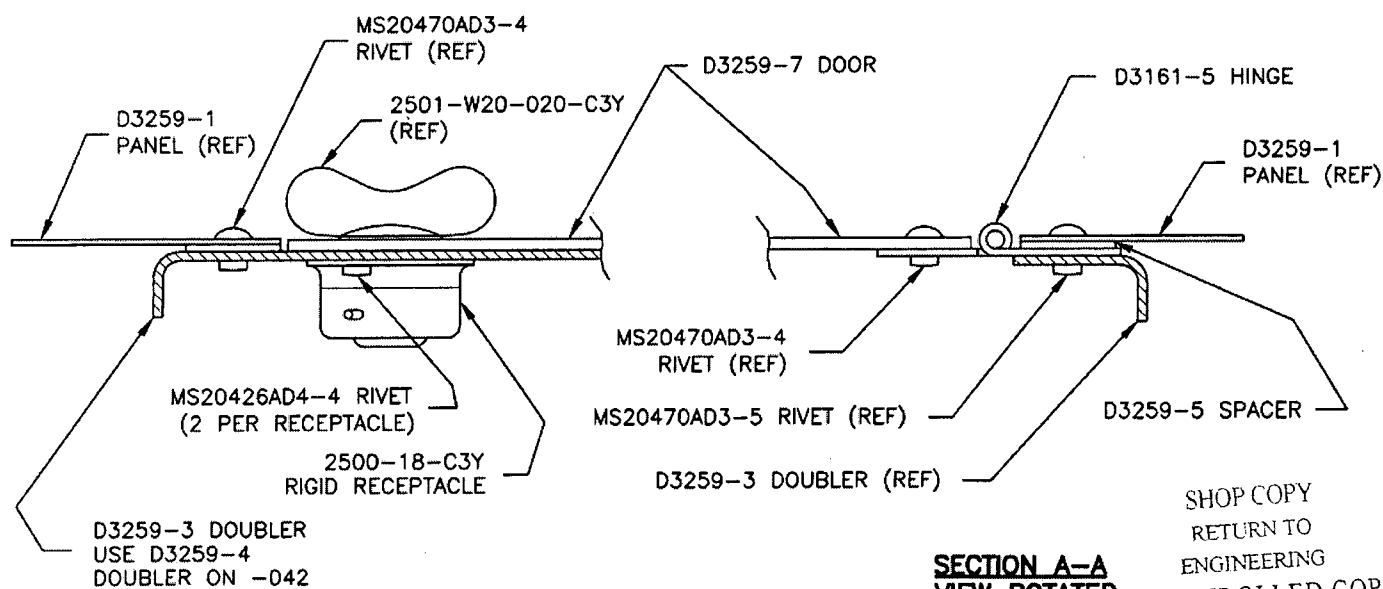
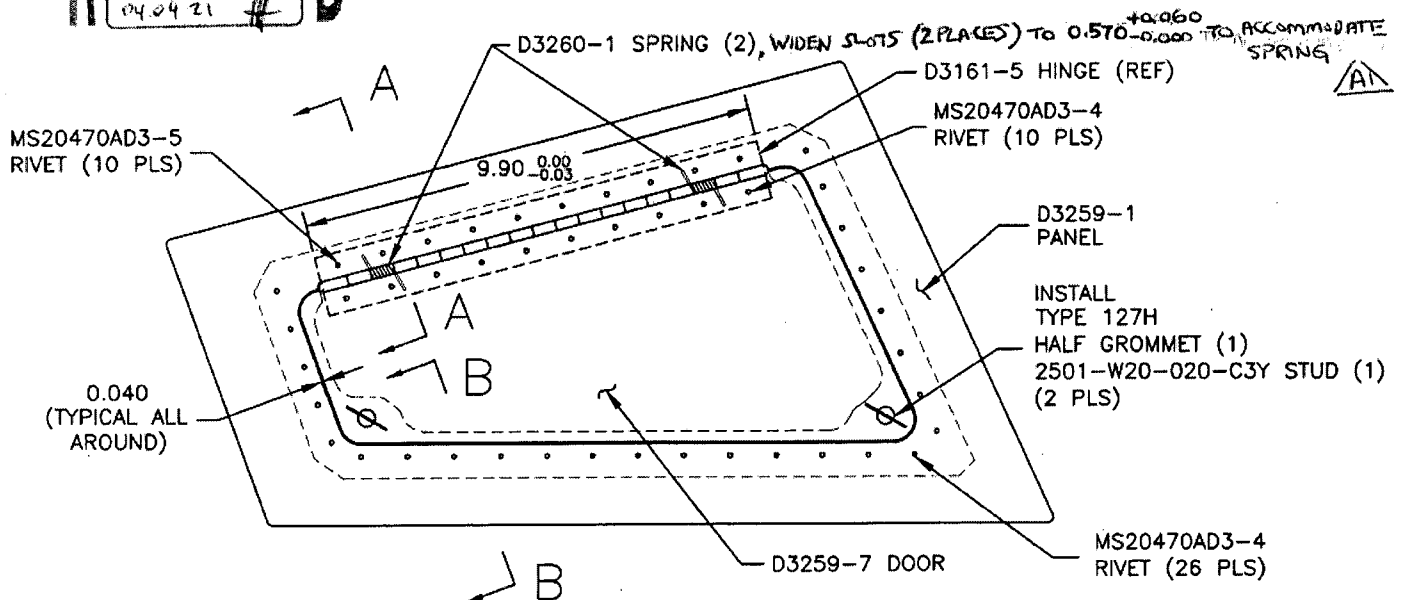
|                        |                       |                            |     |
|------------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> IB | <b>Audited by:</b> En | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 07-09-28  | <b>Date:</b> 07/09/28 | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 04.08.25 | New Issue | KJ/JLM     |          |



|         |             |          |    |   |                        |
|---------|-------------|----------|----|---|------------------------|
| DESIGN  | RF          | DRAWN BY | CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED | TH          | APPROVED | TH | DRAWING NO.<br>D3259                              | REV. A<br>SHEET 1 OF 6 |
| DATE    | 04.02.25    |          |    | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |
| A       | 04.02.25    |          |    | NEW ISSUE   |                        |
| A1      | CP 04.08.11 |          |    | WIDEN SLOTS TO ALLOW OPERATION OF SPRING          |                        |

RELEASED  
040421



SECTION B-B  
VIEW ROTATED

SECTION A-A  
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)  
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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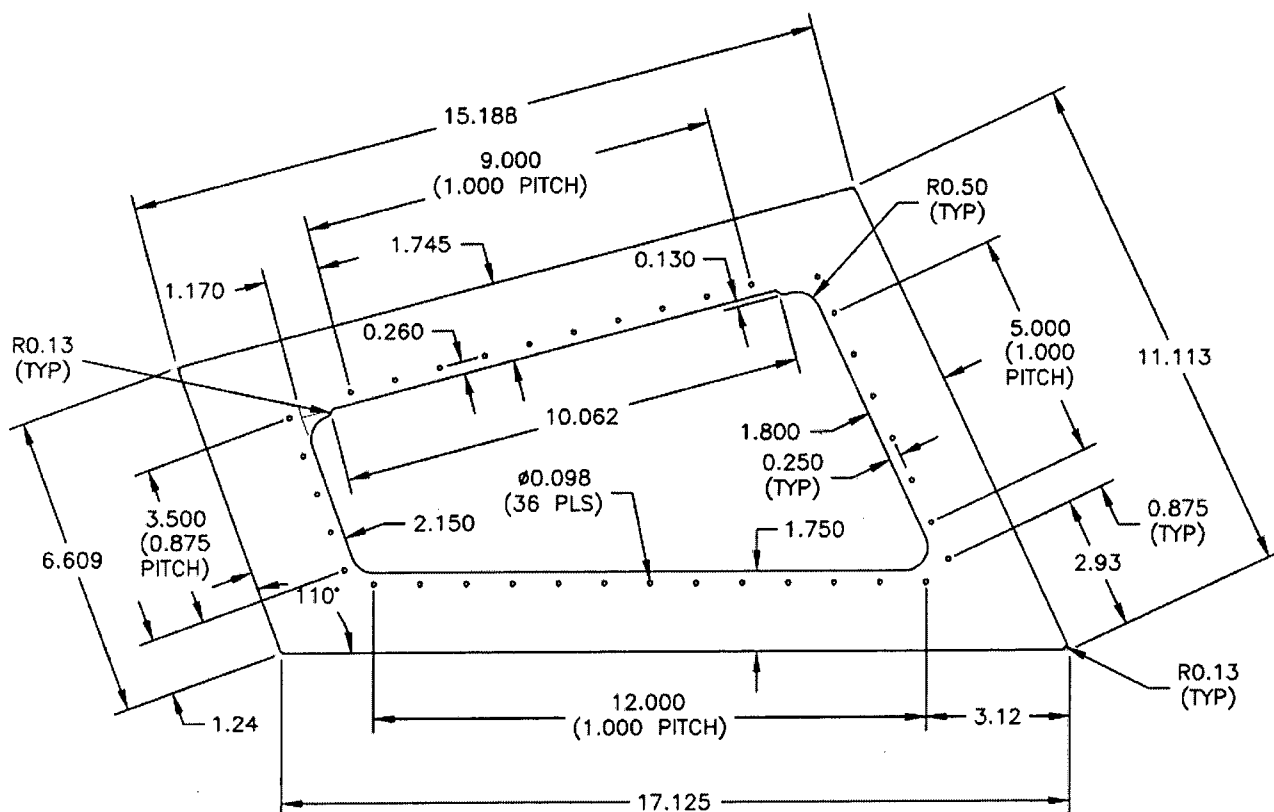
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| DATE<br>04.02.25 |               | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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04.04.05



### D3259-1 PANEL

#### NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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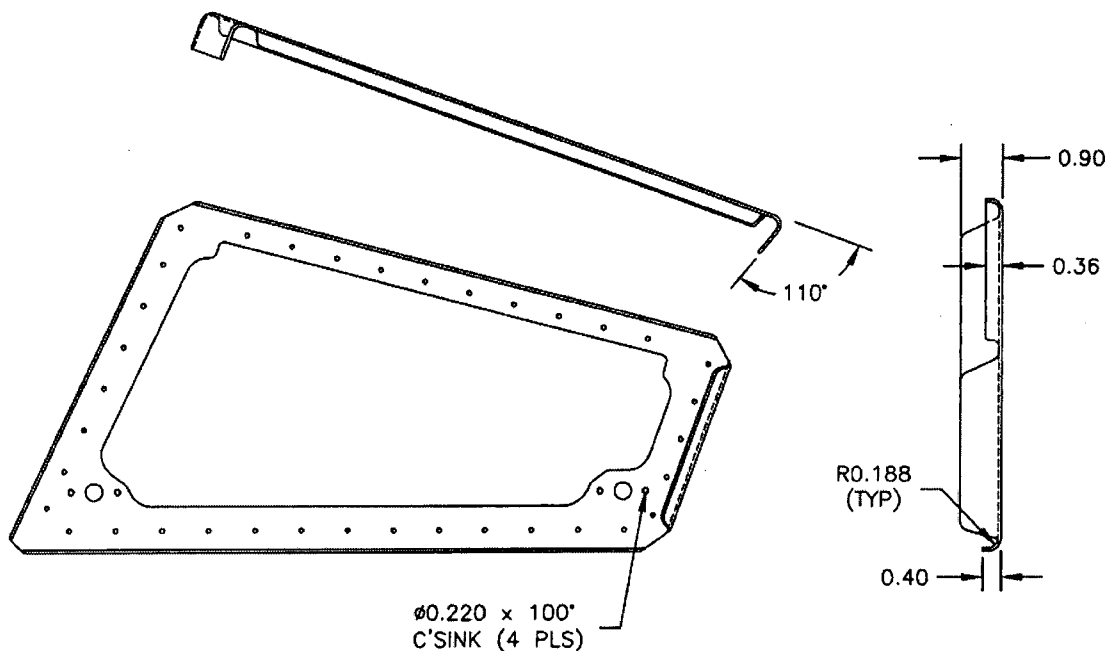
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| DATE<br>04.02.25 |               | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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04.04.14



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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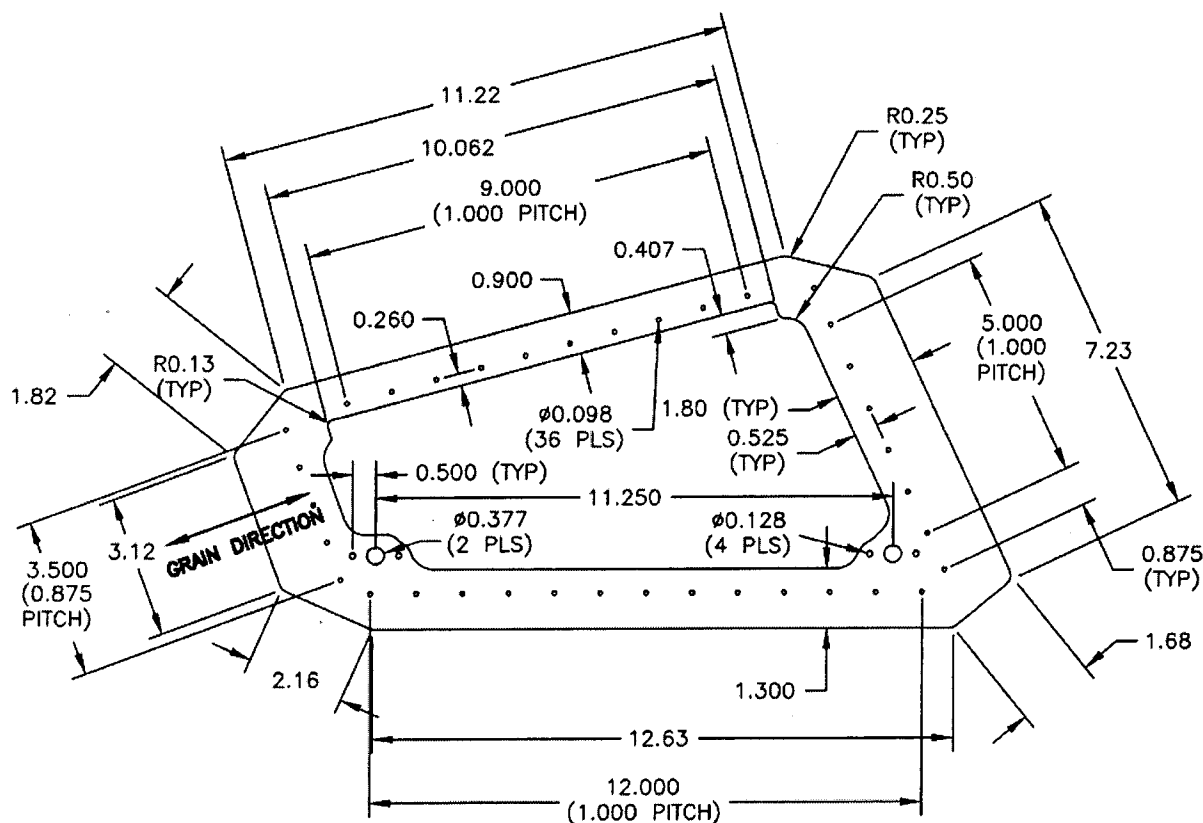
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| DATE<br>04.02.25              |                                | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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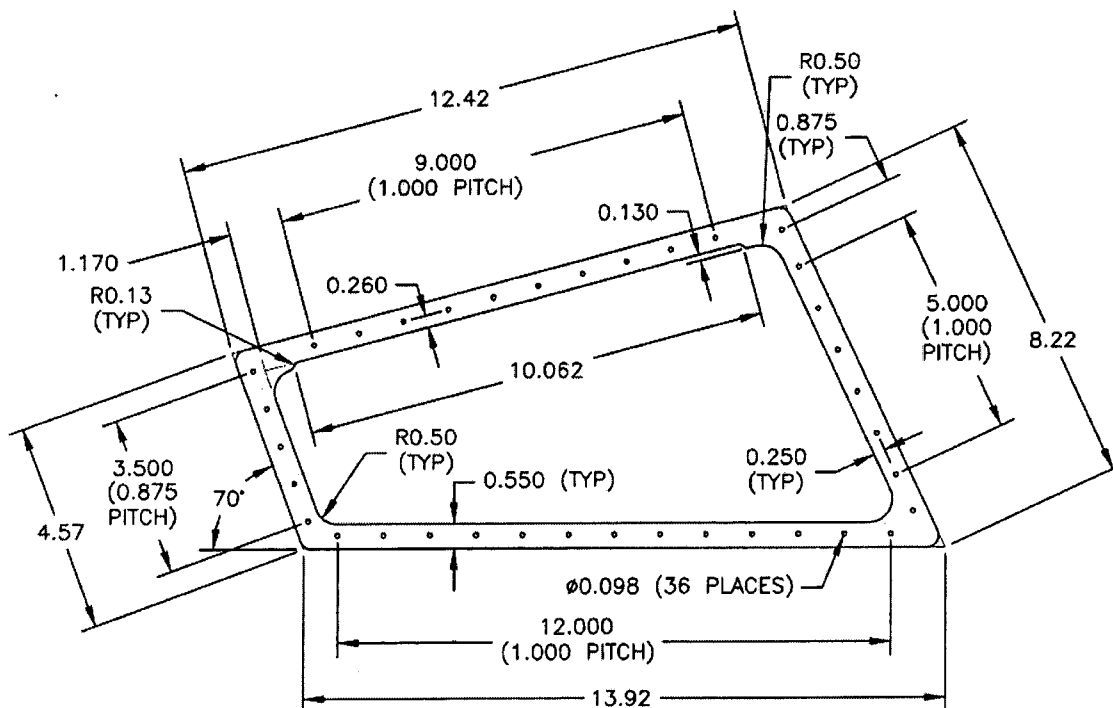
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| DATE<br>04.02.25 |               | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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04.02.05



### D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

#### NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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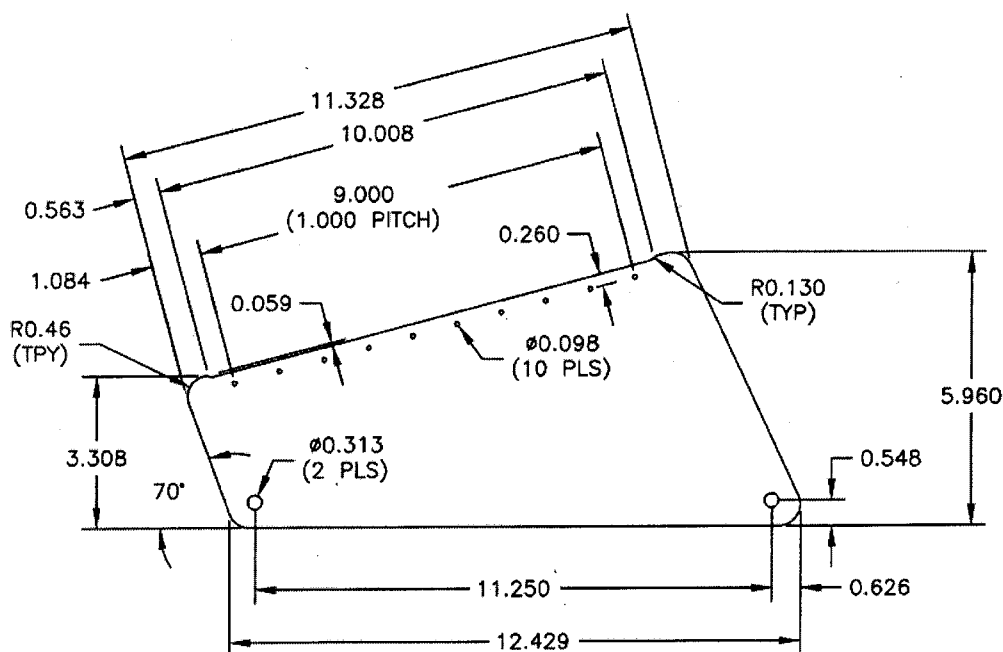
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| DATE<br>04.02.25              |                                | TITLE<br>ACCESS PANEL ASSEMBLY                    | SCALE<br>1:4           |

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04.04.14 *[Signature]*



**D3259-7 DOOR**

**NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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